

STOP ASAP

Work Order ID 55137

January 7, 2010 8:19:24 AM



Page 1

Item ID: DSI 9420-013

Accept



Setup Start



Revision ID: B

Stop



Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 1/07/10

Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10

Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

DSI 9420

B

100

0.00



DC

Document Control

Memo

0.00

Photocopy bluefile & type labels per PPP DSI 9420-013
CHG001

5 10/60/08

10-1-07

110

Pick Kit

0.00



Packaging

Packaging

Memo

0.00

10-1-7

24

120

QC4- 100% Inspect kits for completeness

0.00



QC

Quality Control

Memo

0.00

5 10/60/08

22

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Page 2

Item ID: DSI 9420-013

Accept



Setup Start



Revision ID: B

Stop



Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 1/07/10 Start Qty: 2.00



Cust Item ID:

Required Date: 1/08/10 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

0.00



Packaging

Memo

0.00

Identify and pack for shipping as per PPP DSI 9420-013

Location: _____

PPP rev: A

10-1-8 sf 2x

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/01/08

W 10-01-08

Picklist Print

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Page 1

Work Order ID: 55137

Parent Item: DSI 9420-013

Parent Item Name: Run-On Landing Wearplate Upgrade, High Gear


Start Date: 1/07/10

Required Date: 1/08/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN3-37A  Bolt	+7	Purchased	No			110	Each	719.0000	14.0000		10-1-7	SP

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

719

105425

219

111668

500

110

Each

998.0000

14.0000

14

10-1-7

SP (2x)

AN960JD10



Washer

Purchased

No

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

998

105442

8

109059

2

109840

23

110139

2

110985

202

111279

5

111668

48

112314

78

112369

22

113149

608

14

Picklist Print

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Page 2

Work Order ID: 55137

Parent Item: DSI 9420-013

Parent Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 1/07/10

Required Date: 1/08/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	--------------------------	---------------	----------------	--------

D2649 +2

Manufactured

No

110

Each

202.0000

4.0000



Cross Bolt Spacer



10-1-7 SP

(24)

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

LG

83

51529

83

Main Warehouse

ST

119

36013

5

47112

110

48271

4

D3805-043 +1

Manufactured

No

110

Each

0.0000

2.0000



Wearplate Assembly Fwd, High Gear



BSS 138

10-1-8 SP

D3805-047 +1

Manufactured

No

110

Each

0.0000

2.0000



Wearplate Assembly Aft, High Gear



BSS/39

10-1-8 SP

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Shop Packet Print

Page 2

Picklist Print

January 7, 2010 8:19:22 AM

Work Order ID: 55137

Parent Item: DSI 9420-013

Parent Item Name: Run-On Landing Wearplate Upgrade, High Gear

Start Date: 1/07/10

Required Date: 1/08/10

Comments:

Start Qty: 2.00

Required Qty: 2.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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D3873-1 *1214*

Manufactured

No

110

Each

39.0000

28.0000



Bushing

10-1-7

sf

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

25

53443

25

14

Main Warehouse

ST139

14

50479

14

14

MS21042-3 *7*

Purchased

No

110

Each

100.0000

14.0000



USE MS21042L3

M112314

10-1-7

2X 50

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

100

111650

100

9.0 DSI 9420-011/-013 RUN-ON LANDING WEARPLATE UPGRADE KIT INSTALLATION

- 9.0.1 Remove the D206-642-111/-112/-211/-212/-213/-214 Skidtube per Section 32.1 of ICA-D206-642 Rev. 1 or earlier. Remove existing wearplates. Inspect the bottom of the tube for damage and touch up finish per Section 5.2.11 of ICA-D206-642 Rev. 1 or earlier. Plug existing wearplate inserts using Sikaflex-241/-291 or Proseal 890.
- 9.0.2 Remove qty(10) D2651-1 Plugs where the AN3 Bolts will be inserted to install the run-on landing wearplate assemblies. Refer to Figure 2.
- 9.0.3 Locate and temporarily install the Wearplate Assemblies per Figure 1. On both sides of the skidtube, transfer drill qty(2) Ø0.375" holes from the Wearplate Assembly to the Skidtubes as shown in Figure 2. Countersink the holes on both sides to Ø0.450" X 45°. Deburr.
- 9.0.4 Install D2649 Spacer per Sections A-A or B-B using Magnobond 6398. Grind flush as required. Allow Magnobond to cure per manufacturer's instructions.
- 9.0.5 Install the D3805-XXX Wearplate Assemblies using the qty(7) AN3-37A bolts and associated fasteners, as shown in Figure 1 of this service instruction. Torque fasteners to 15-25 in-lb (1.7-2.8 N-m).
- 9.0.6 Reinstall the Skidtube on the aircraft per Section 32.2 of ICA-D206-642 Rev.1 or earlier.
- 9.0.7 Update weight and balance information per Section 6.0 of this service instruction. Customers upgrading D206-642-111/-112 Skidtubes should adopt Weight & Balance of D206-642-113/-114 Skidtubes and customers upgrading D206-642-211/-212/-213/-214 Skidtubes should adopt Weight & Balance of D206-642-215/-216/-217/-218 Skidtubes.

10.0 DSI 9420-011/-013 PARTS LIST

Qty -011	Qty -013	Part Number	Description
X		DSI 9420-011	RUN-ON LANDING WEARPLATE UPGRADE KIT, LOW GEAR
	X	DSI 9420-013	RUN-ON LANDING WEARPLATE UPGRADE KIT, HIGH GEAR
2	2	D2649	SPACER
1		D3805-041	FWD WEARPLATE ASSY
1		D3807-1	* GASKET (1)
	1	D3805-043	FWD WEARPLATE ASSY
	1	D3807-3	* GASKET (2)
1		D3805-045	AFT WEARPLATE ASSY
1		D3807-5	* GASKET (3)
	1	D3805-047	AFT WEARPLATE ASSY
	1	D3807-7	* GASKET (4)
14	14	D3873-1	BUSHING
7	7	AN3-37A	*BOLT
7	7	AN960JD10	WASHER
7	7	MS21042-3	NUT (OR MS21042L3)

NOTES: (1) DENOTES THAT PART IS INCLUDED WITH D3805-041 ASSEMBLY ABOVE
(2) DENOTES THAT PART IS INCLUDED WITH D3805-043 ASSEMBLY ABOVE
(3) DENOTES THAT PART IS INCLUDED WITH D3805-045 ASSEMBLY ABOVE
(4) DENOTES THAT PART IS INCLUDED WITH D3805-047 ASSEMBLY ABOVE

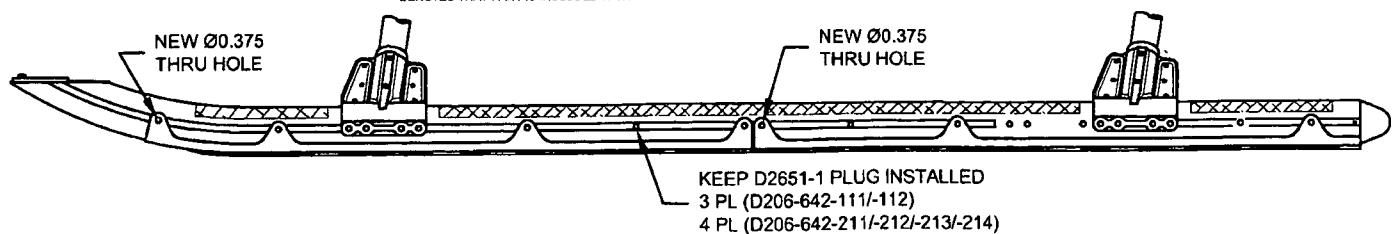


FIGURE 2: D206-642-111/-112/-211/-212/-213/-214 SKIDTUBE MOD

(D206-642-111/-112 SHOWN - D206-642-211/-212/-213/-214 SIMILAR)

DESIGN	94	DART AEROSPACE USA, INC	
DRAWN	AJS	PORT HADLOCK, WA	
CHECKED	11	DRAWING NO.	REV. B
MFG. APPR.	N/A	DSI 9420	SHEET 6 OF 6
APPROVED	11	TITLE	SCALE
DE APPR.	11	SKIDTUBE INSTALLATION	NTS
DATE	09.03.25	COPYRIGHT © 2008 BY DART AEROSPACE USA, INC	
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